

Work Order ID 63265

Wednesday, October 27, 2010 9:05:34 AM

Page 1

Item ID: D212-725-1-123F

Accept

Setup Start

Revision ID:

Stop

Item Name:

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

F

100

0.00



Waterjet

FLOW CNC Waterjet

2024 .063

Memo

1-Cut as per Dwg

Dwg Rev: F

Prog Rev: F

2-Deburr if necessary

0.00

HB 10-10-27

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

HB 10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63265

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Page 2

Item ID: D212-725-1-123F

Accept



Setup Start



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Stop



Start Date: 10/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							
121 Hand Finish	Memo: see Attached email for dentin and hubs. Acid to Alodine								2
122 Qc 3									10-10-28
130 	Identify as per dwg & Stock Location: 383	0.00							
Packaging	Memo	0.00							
Packaging	***FLAT PATTERN ONLY***								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

2

2

10/10/28

10/10/29

10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Wednesday, October 27, 2010 9:05:39 AM

Page 1

Work Order ID: 63265

Parent Item: D212-725-1-123F

Parent Item Name:



Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

89.0000

2.597

5.467368



2024-T3 .063 sheet

1310-10-27

Location

Loc Qty

Loc Code

MAT22

89

113866

8.5

114351

80.5

113866

②

W/O:		WORK ORDER CHANGES					
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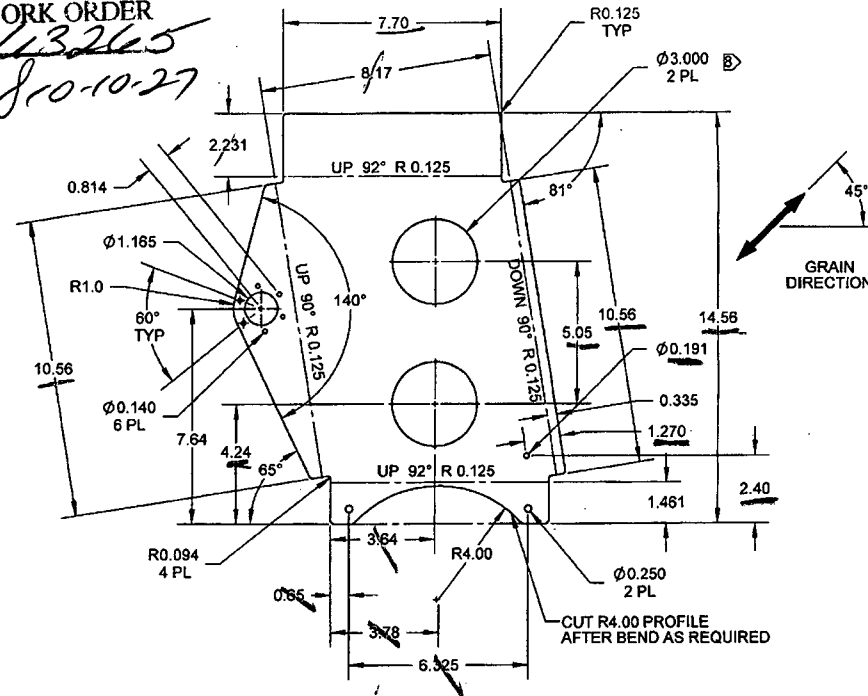
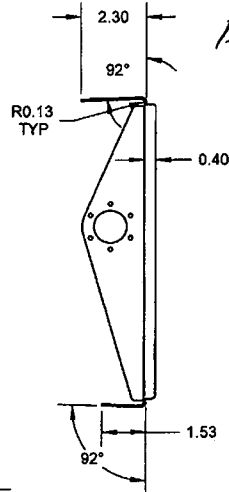
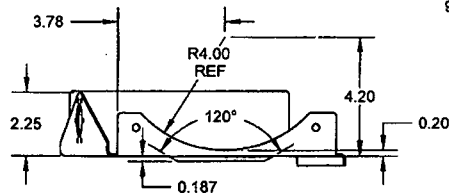
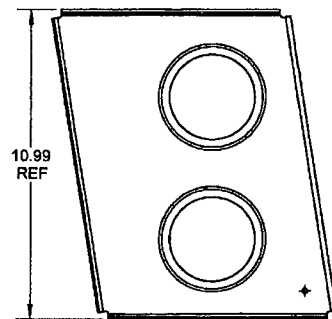
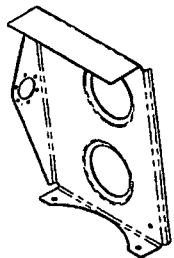
D212 - 725 - 1-123

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-10-27	Date:	10/10/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *43265*
BS-10-10-27



D212-725-1-123F FLAT PATTERN

D212-725-1-123 BRACKET
(MAKE FROM D212-725-1-123F FLAT PATTERN)

NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.063 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) USE 3.0 FLANGE TOOL AFTER BEND, 2 PLACES

RELEASED
9/24/07

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		D212-725-1	SHEET 40 OF 84
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.02.02	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NOTE: Date & initial all entries

L Lacelle

From: Robert Fuentes [rfuentes@dartaero.com]

Sent: October 27, 2010 1:03 PM

To: 'L Lacelle'

Cc: 'H. Siemens'; 'David Shepherd'

Subject: RE:

That be ok Linda, send that part as is, If they have problem I correct that when we release D-4 digits number.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]

Sent: Wednesday, October 27, 2010 9:47 AM

To: 'Robert Fuentes'

Cc: 'H. Siemens'; 'David Shepherd'

Subject: FW:

Roberto,

I have had these cut already to the dxf's you supplied, I can charge Eagle for the scrap parts, or you take them as is...what is your preference?

Please next time let someone know that the dwg or dxf is changed, we NEVER receive an ECN for the change in these parts, so no one knows about it!

LL

From: David Duval [mailto:dduval@dartaero.com]

Sent: October 27, 2010 11:43 AM

To: Linda Lacelle

Subject:

d212-725-1-123 do we cut it or what

[11:31:31 AM] David Duval: the rad is at 4.00"

[11:34:53 AM] Roberto Fuentes: the new radius is 3.75" from same center as old

[11:36:13 AM] David Duval: send me the new dxf with the new dwg

[11:41:32 AM] Roberto Fuentes: ok, I will send to replace old file that you have.

[11:42:22 AM] David Duval: plus the dxf you sent me is missing the 2 bottom hole .25"

David Duval

Production Engineering Coordinator



1270 Aberdeen Street

Hawkesbury Ontario

Canada K6A 1K7

Tel: (613) 632-5200

dduval@dartaero.com



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10/27/10